

Work Order ID 147490-1

Thursday, June 09, 2016 8:39:55 AM

147490

Ship Sept 23

Page 1

Item ID: 647.3914

Revision ID:

Item Name: Breakaway Tip. Long

Start Date: 5/30/2016 Start Qty: 6.00

Required Date: 6/8/2016 Req'd Qty: 6.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

6 12/5K
6

Approvals: Process Plan: MJS

QC:

Date: JUN 10 2016 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject # Insp. Number Stamp

Draw Nbr

Revision Nbr

647.3900

C2

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 14.500"

12 0

DAS
14
9-89

16/08/26

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB315

DWG REV: CB

FOLIO REV: AA

2- deburr and break all sharp edges

12 0

DAS
14
9-89

16/08/26

710

DQA: dat Date: 2016-10-7QA Closed: RN Date: OCT 03 2016

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>147490</u> Part No. <u>647.3914</u> NCR No. <u>16-6073</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date: <u>16/08/30</u>	Step #: <u>110</u>	QTY Effective : <u>①</u>		MRB (QSI042) Approval <u>DAS 9 9-89</u> <u>16-08-30</u>																																																																	
Description Work Order Deviation chatter marks found at bottom section of blade (sheet 6.c6). Employee use a grinder with red wheel to remove marks. but after thickness of material was under tolerance by .002" See attach drawing for dimension locations.		Disposition <u>acceptable</u> <u>DAS 14 9-89</u> <u>16/08/30</u>		Completed By <u>DAS 14 9-89</u> <u>16/08/30</u> Lead hand / Supervisor Approval Verification <u>D.O 16/08/30</u> QC / QA Coordinator Approval <u>DAS 9 9-89</u> <u>16-08-30</u>																																																																	
Root Cause <table style="width:100%; font-size: x-small;"> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☒</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☒	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%; font-size: x-small;"> <tr> <td>Pressure/Forced ☐</td> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☒</td> </tr> <tr> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>				Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☒	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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OTHER :																																																																					

Work Order ID 147490

Thursday, June 09, 2016 8:39:55 AM

147490

Page 2

Item ID: 647.3914**Revision ID:****Item Name:** Breakaway Tip, Long**Start Date:** 5/30/2016 **Start Qty:** 6.00**Required Date:** 6/8/2016 **Req'd Qty:** 6.00**Reference:**

Accept

N9000040100Setup Start ***NS1***Stop ***NS2*****Cust Item ID:****Customer:****Approvals:** **Process Plan:****Date:****Tooling:****Date:**Run Start ***NR1*****QC:****Date:****SPC (Y/N):****Date:**Stop ***NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp**

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

DAS
14
9-89

16/08/26

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

DAS
32
9-89DAS
45
9-89

16-08-30

140

Outsource process-Anodize per QSI017 4.1,10.1

0.00

140

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O to ATG : 33573

1- Black Anodize as per Dwg 647.3900

2- PRIME AS PER DWG. SEE NOTE #9

Certification of Conformity is required

12

SEP 08 2016

DAS
13
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Work Order ID 147490

Thursday, June 09, 2016 8:39:55 AM

147490

Page 3

Item ID: 647.3914

Revision ID:

Item Name: Breakaway Tip. Long

Start Date: 5/30/2016 Start Qty: 6.00

Required Date: 6/8/2016 Req'd Qty: 6.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.00

Packaging

6x 8/16 9-14

155

QC5- Inspect part completeness to step on W/O

0.00

155

QC

Memo

0.00

Quality Control

6

DAS
38
9-89

SEP 23 2016

180

Identify as per dwg & Stock Location: Ck 1006

0.00

180

Packaging

Memo

0.00

Packaging

6

DAS
6
9-89

SEP 23 2016

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Work Order ID 147490

Thursday, June 09, 2016 8:39:55 AM

147490

Page 4

Item ID: 647.3914

Revision ID:

Item Name: Breakaway Tip, Long

Start Date: 5/30/2016 Start Qty: 6.00

Required Date: 6/8/2016 Req'd Qty: 6.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

6***6***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

DAS
21
9-89

SEP 23 2016

DAS
21
9-89

SEP 23 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					

Picklist Print

Thursday, June 09, 2016 8:40:01 AM

Page 1

Work Order ID: 147490

147490

Parent Item: 647.3914

647.3914

Parent Item Name: Breakaway Tip, Long

Start Date: 5/30/2016

Required Date: 6/8/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV. A NEW ISSUE JFS 14/06/19 VERIFIED BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B2.000X00.75 0		Purchased	No			100	f	27.8383	1.209	7.63579			

M7075T6B2 000X00 750

7075-T6 BAR 2.000" X 0.750"

**

14.6665'

DAS
20
9-89

16-08-19

Location

Loc Qty

Loc Code

MAT001

19.8333

134327

19.8333

MAT005

8.005

m131022

3.33

m134214

4.675

8.604'

2.4375'

3.625'

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____					



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO. 04948

SHEET 1 OF 2

DWG NO. 647.3900

REV: C

PREPARED BY: M. ANDECK

DATE: 05/04/15

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: DEFLECTORS

APPROVED BY:

ENGR

MFG

QC

EFF:

CURRENT ORDER

TRANSACTION CODES (TC):

A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED TOLERANCE AND NOTES

ECR:

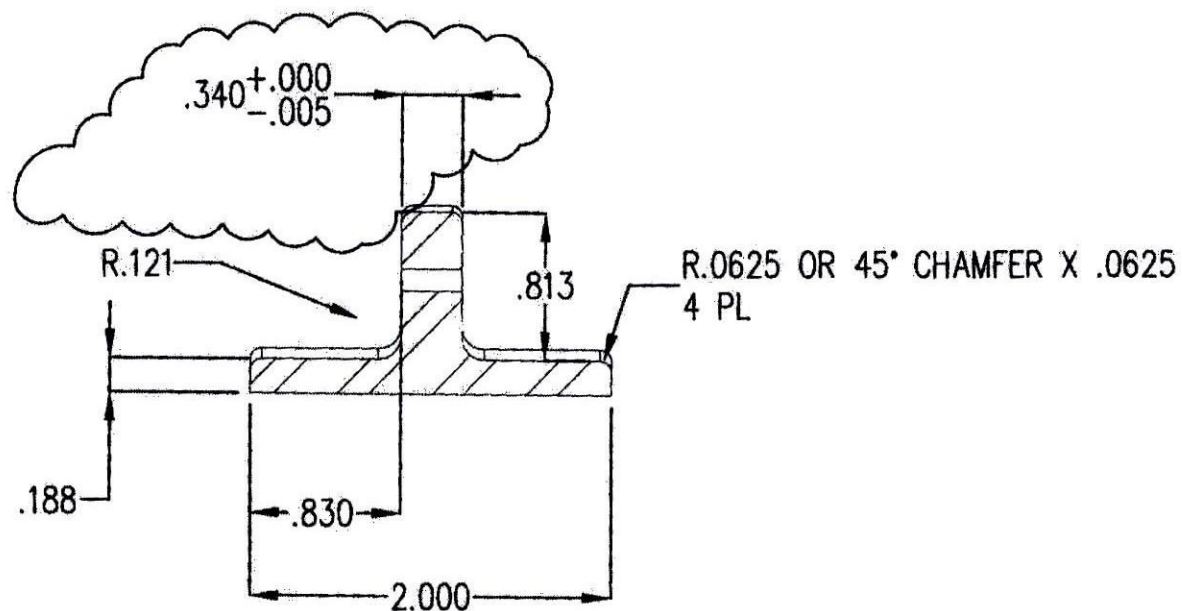
D-15-01

NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 APPLY F/N 3 AS REQUIRED TO ALL FAYING SURFACES OF F/N 6, 7 & 8 UPON ASSY.
- 6 MAXIMUM OR MINIMUM DIMENSION AFTER FINISH.
7. .0625 HOLE MAY BE ADDED FOR FINISHING PURPOSES
- 8 FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N; 1-2 MIL MAX. APPLY FINISH AFTER ASSEMBLY.
- 9 FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N; 1-2 MIL MAX.
- 10 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.

SHEET 1, ZONE B1 IS:

11	R	647.3917	2			DOUBLER		
F/N	TC	PART NUMBER	.3903	.3902	.3901	DESCRIPTION	MATERIAL	SPECIFICATION
			QTY					
DOCUMENTS EFFECTED:							CHANGE CATEGORY	DER REVIEW REQUIRED
☐ PATTERN ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☒ BOM							☐ MAJOR ☒ MINOR	☐ YES ☒ NO



SECTION AT-AT

SHEET 11, ZONE C1 IS:

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04556

SHEET 1 of 2

DWG NO. 647.3900

REV: C

PREPARED BY D. MEJIA

DATE: 06/10/2014

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: DEFLECTORS

APPROVED BY: ENGR

MFG

QC

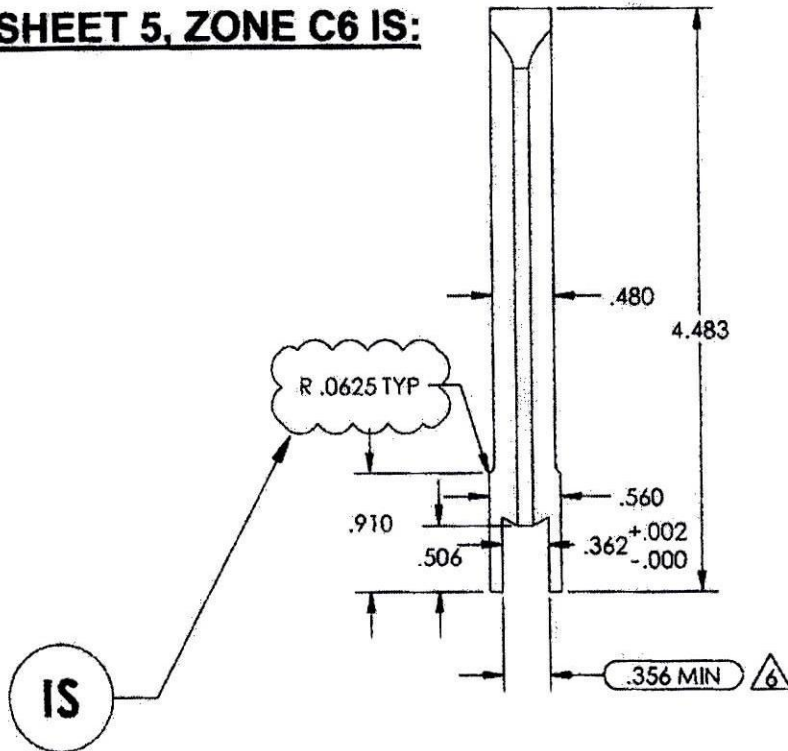
EFF. NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

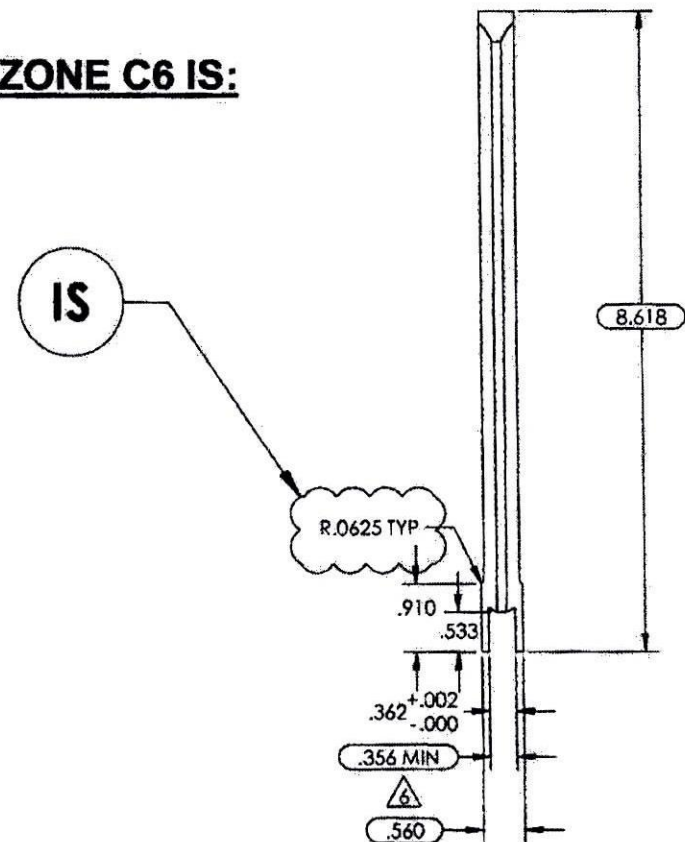
REASON: CHANGED P/N, DIMENSIONS & REVISED BOM

ECR: D-14-04

SHEET 5, ZONE C6 IS:

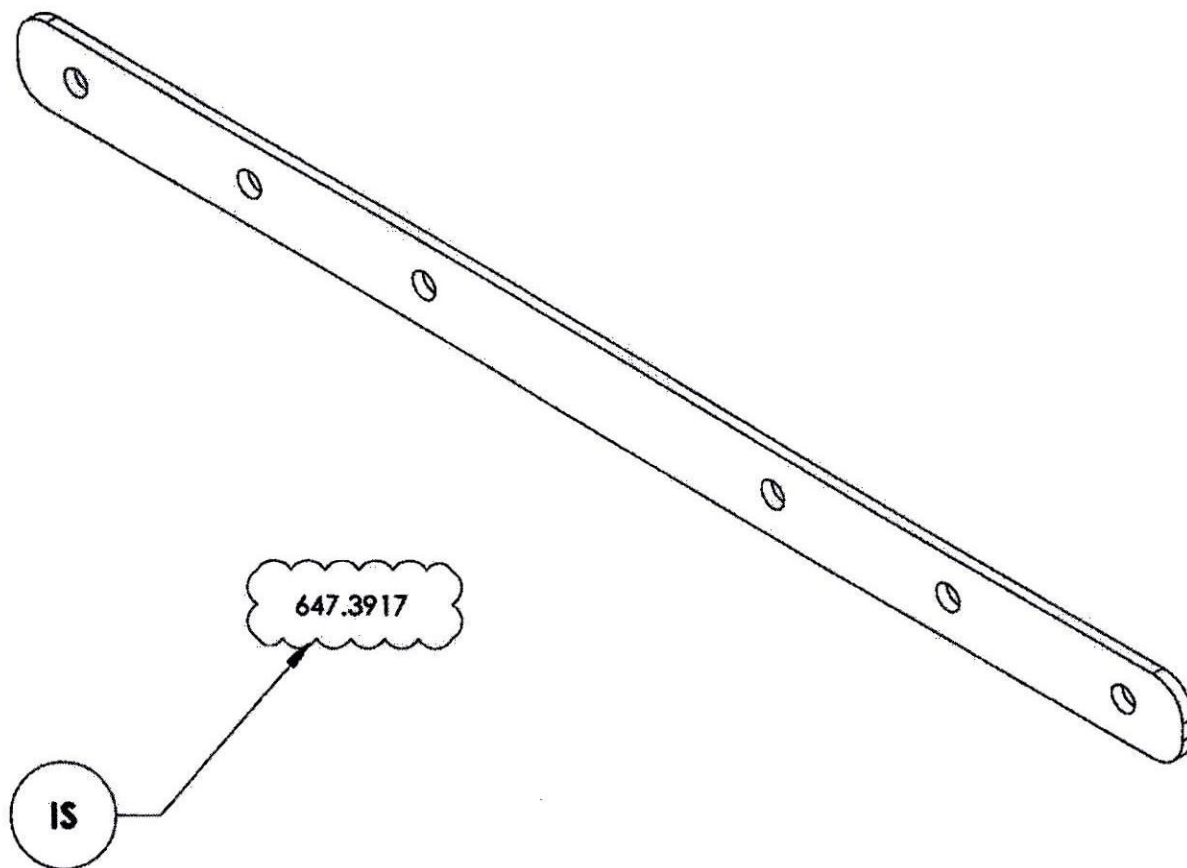


SHEET 6, ZONE C6 IS:



SHEET 1, BOM IS:

11	R	647.3917	2		DOUBLER		
F/N	TC	PART NUMBER	QTY		DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED
☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☒ BOM						☐ MAJOR ☒ MINOR	☐ YES ☒ NO

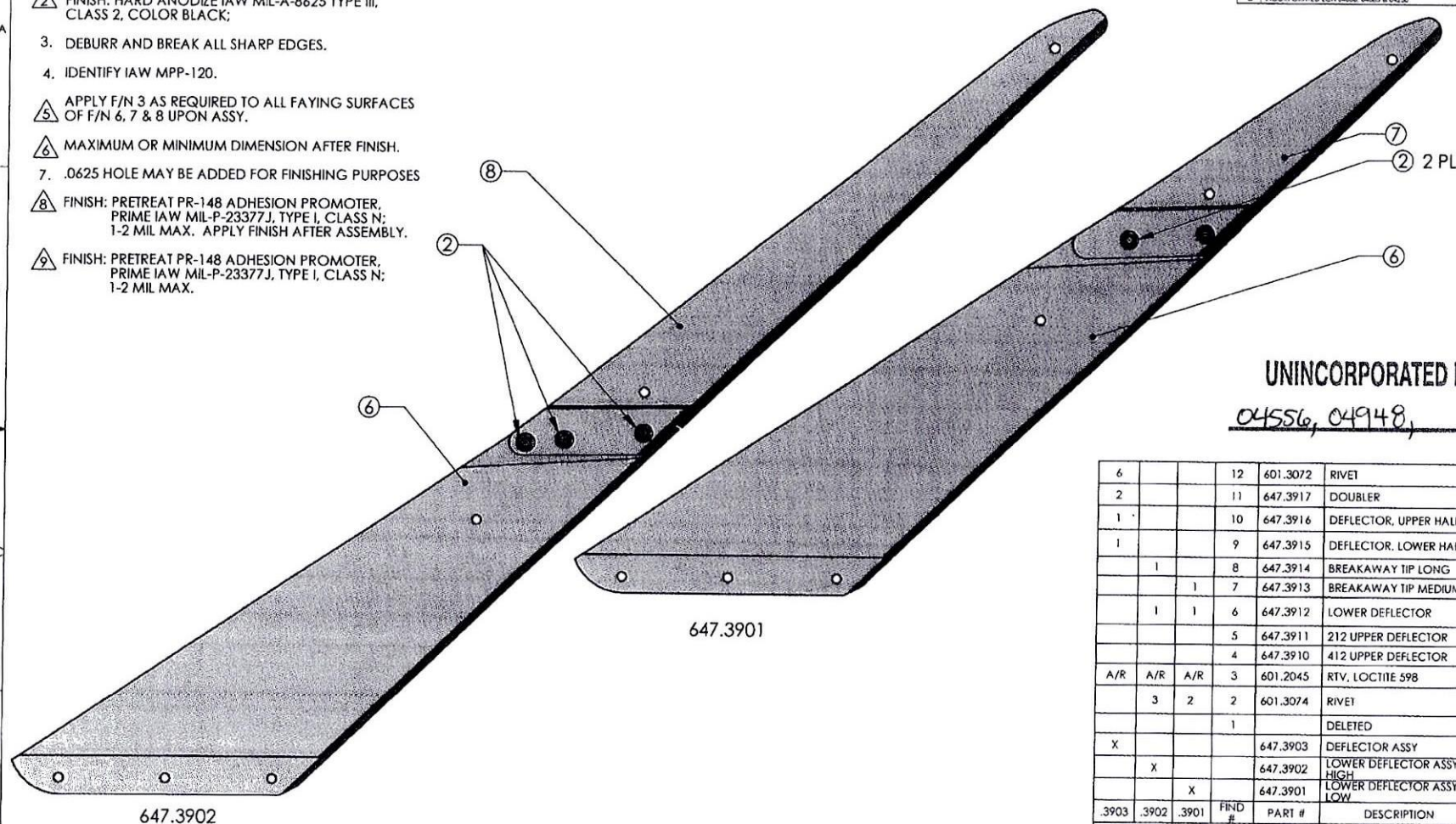
SHEET 12, ZONE B5 IS:

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NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 APPLY F/N 3 AS REQUIRED TO ALL FAYING SURFACES OF F/N 6, 7 & 8 UPON ASSY.
- 6 MAXIMUM OR MINIMUM DIMENSION AFTER FINISH.
7. .0625 HOLE MAY BE ADDED FOR FINISHING PURPOSES
- 8 FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N; 1-2 MIL MAX. APPLY FINISH AFTER ASSEMBLY.
- 9 FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N; 1-2 MIL MAX.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
N/C	LAST PROTOTYPE RELEASE: FRI		N/C
N/C	INITIAL RELEASE	07/10/09	P. BRAVO
A	INCORPORATED ECN 02864, 03039 & 03095	07/24/12	P. BRAVO
B	INCORPORATED ECN 04025	08/02/13	P. BRAVO
C	INCORPORATED ECN 04038, 04083 & 04250	11/18/13	P. BRAVO

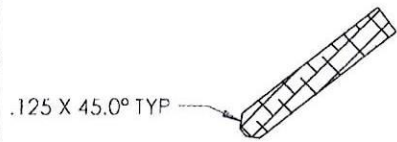


UNINCORPORATED ECN(S)

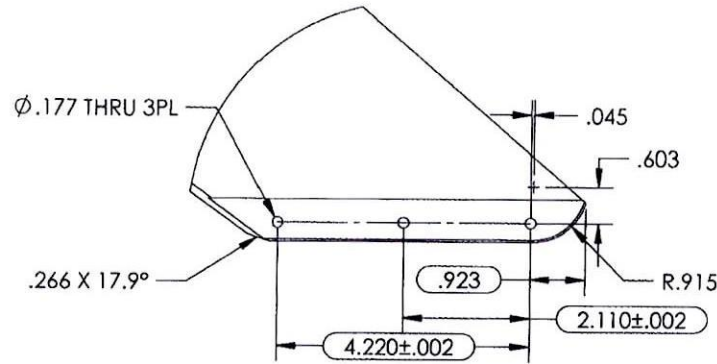
04556, 04948,

6		12	601.3072	RIVET	CR3213-6-9	
2		11	647.3917	DOUBLER		
1		10	647.3916	DEFLECTOR, UPPER HALF	△	△
1		9	647.3915	DEFLECTOR, LOWER HALF	△	△
	1	8	647.3914	BREAKAWAY TIP LONG	△	△△
		7	647.3913	BREAKAWAY TIP MEDIUM	△	△△
	1	6	647.3912	LOWER DEFLECTOR	△	△△
		5	647.3911	212 UPPER DEFLECTOR	△	△△
		4	647.3910	412 UPPER DEFLECTOR	△	△△
A/R	A/R	3	601.2045	RTV, LOCTITE 598		△
	3	2	601.3074	RIVET	MS20470AD 6-12	
		1		DELETED		
X			647.3903	DEFLECTOR ASSY		△
	X		647.3902	LOWER DEFLECTOR ASSY HIGH		
		X	647.3901	LOWER DEFLECTOR ASSY LOW		
.3903	.3902	.3901	FIND #	PART #	DESCRIPTION	MATL SPEC
QTY						
NEXT ASSY (S)				PARTS LIST		
647.3800				APICAL INDUSTRIES		
				2608 TEMPLE HEIGHTS DR.		
				OCEANSIDE, CA. 92056-3512 (760)724-5300		
				DEFLECTORS		
				UNLESS OTHERWISE SPECIFIED		
				DIMENSIONS ARE IN INCHES		
				TOLERANCES ARE		
				2 PLACE DECIMALS ± .01		
				3 PLACE DECIMALS ± .005		
				ANGLES ± .5°		
				SHEET 1 OF 12		
				SCALE NONE		
				REV. C		
				DWG. NO. 647.3900		
				SHEET 1 OF 12		

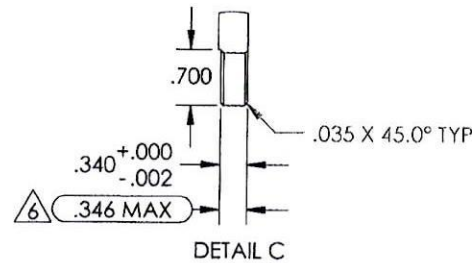
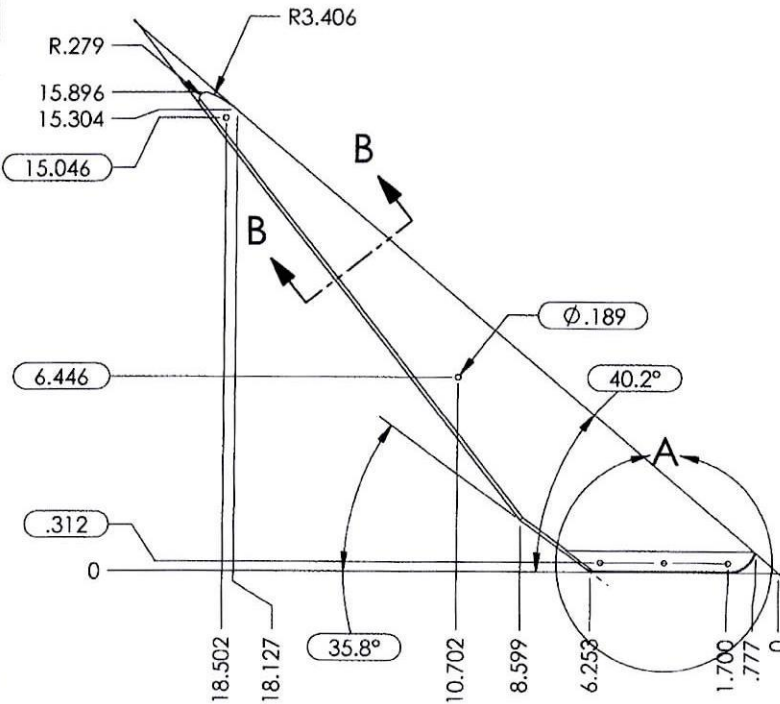
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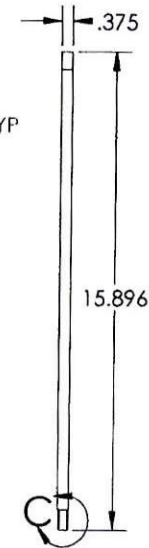
SECTION B-B



DETAIL A



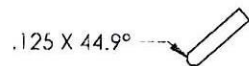
DETAIL C



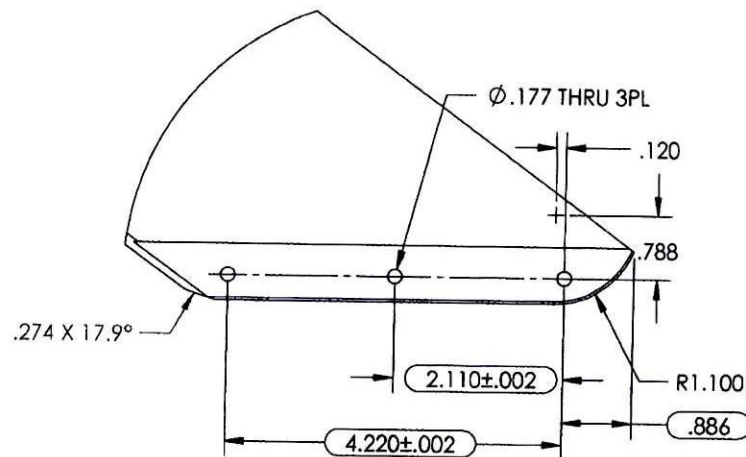
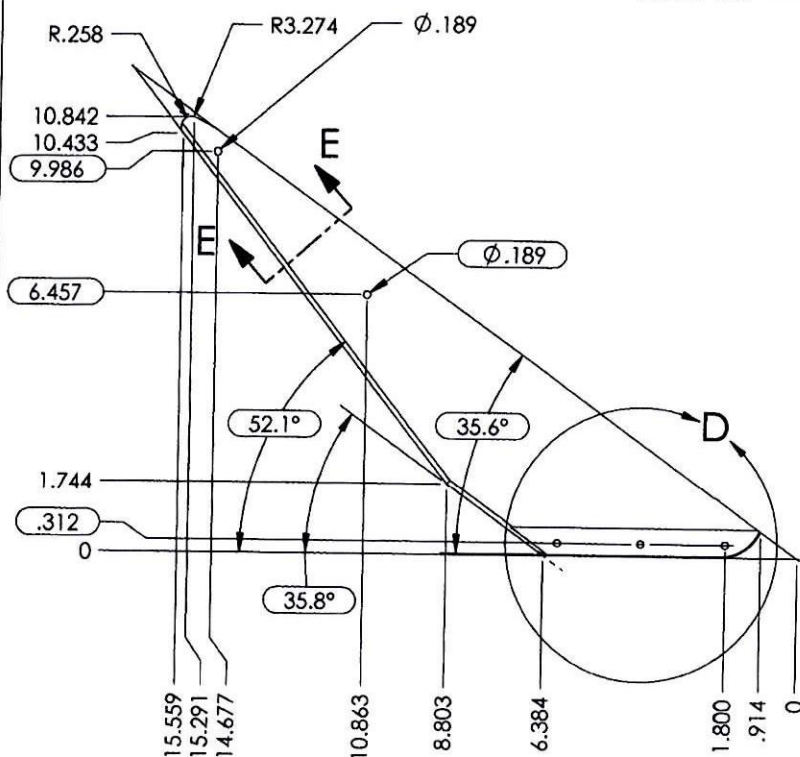
647.3911

ORIGINAL DATE 1/20/2011 09:10:09		APICAL INDUSTRIES	
DRAWN BY D. SCHUB	CHECKED D. BARKER	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BAYCO 2011-02-09		DEFLECTORS	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SHEET B	REV. C
CAGE CODE 07MZ6		DWG. NO. 647.3900	SCALE NONE
		SHEET 2 OF 12	

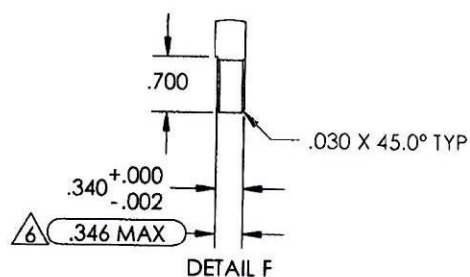
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



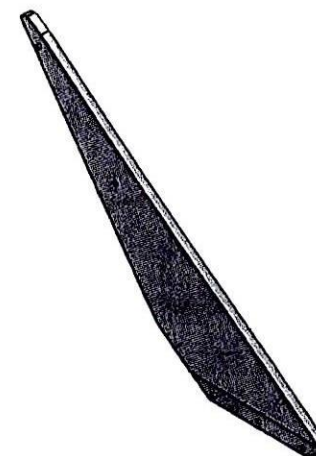
SECTION E-E



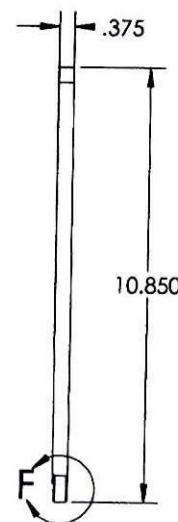
DETAIL D



DETAIL F

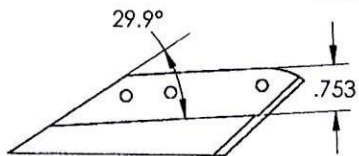


647.3910

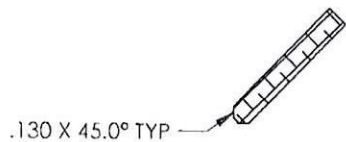


ORIGINAL DATE JUN-04-1971 09:10:49		APICAL INDUSTRIES	
DRAWN BY D. SCHUP		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAYO		DEFLECTORS	
CONTRACT NO.		647.3900	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm$.01 3 PLACE DECIMALS $\pm$.005 ANGLES $\pm$.5°		SHEET B	REV C
SCALE: NONE		SHEET 3 OF 12	

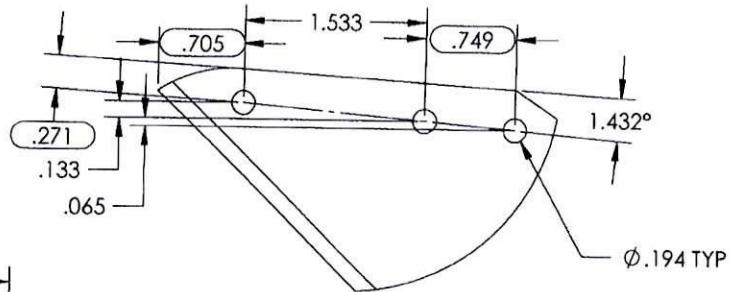
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



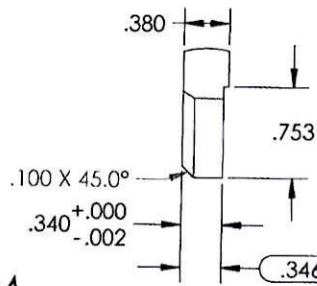
SECTION L-L



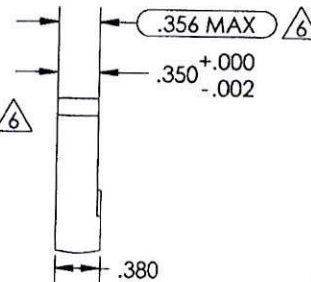
SECTION M-M



DETAIL H



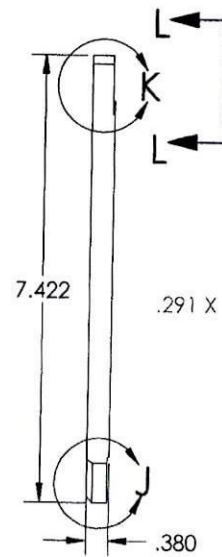
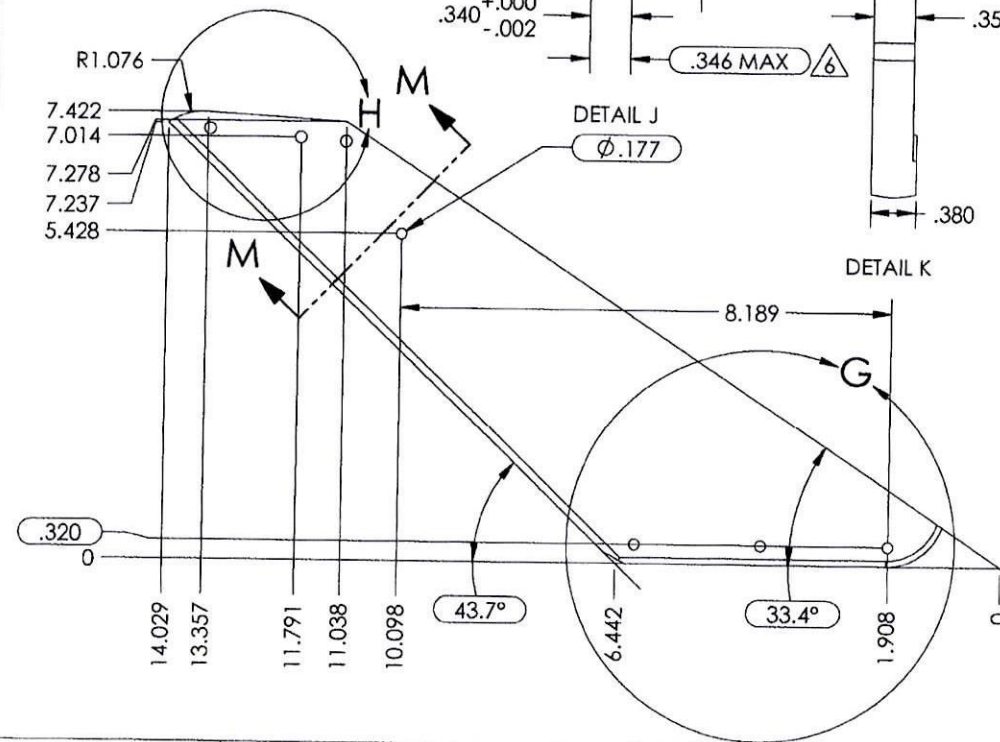
DETAIL J



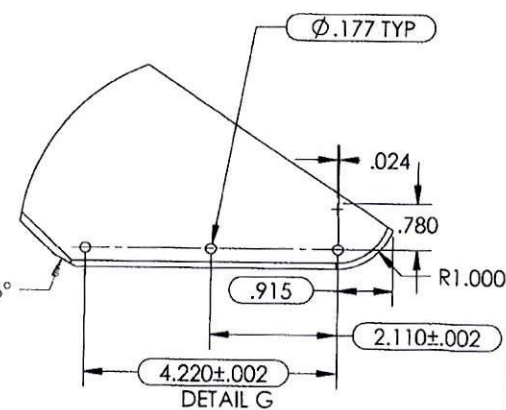
DETAIL K



647.3912



DETAIL G



ORIGINAL DATE: 09-10-09		APICAL INDUSTRIES	
DRAWN BY: J. SCHUP		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: J. HANF		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL: P. BRAVO		DEFLECTORS	
CONTRACT NO: 00-500		SCALE: NONE	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE: CAGE CODE: B 07M26	DWG. NO: 647.3900
		REV: C	SHEET: 4 OF 12

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180 X 45.0° TYP

SECTION N-N

R.269

R3.534

4.483

3.696

41.9°

4.029

3.414

3.284

1.780

0

R.264

0

31.4°

Ø.189 THRU 2PL

Ø.194 THRU 2PL

1.196

.506

.337

0

3.376

.917

1.504

3.135

R1.675

.130

.417

SECTION AD-AD

647.3913

4.483

.480

AD

.560

.362^{+0.002}_{-.000}

.506

R.050

.910

AD

.356 MIN

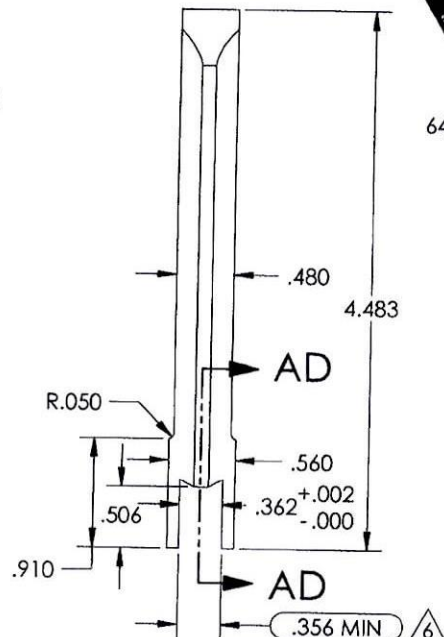
6

ORIGINAL DATE (MM-DD-YY)	09-10-01
DRAWN BY	OSCHUR
CHECKED BY	ED BARKER
DRAWING APPROVAL	P. BRAVO
CONTRACT NO.	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.001
ANGLES ±.5°

SET	CAGE CODE	DWG. NO.
B	07M26	647.3900
SCALE NONE		

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-
DEFLECTORS
SHEET 5



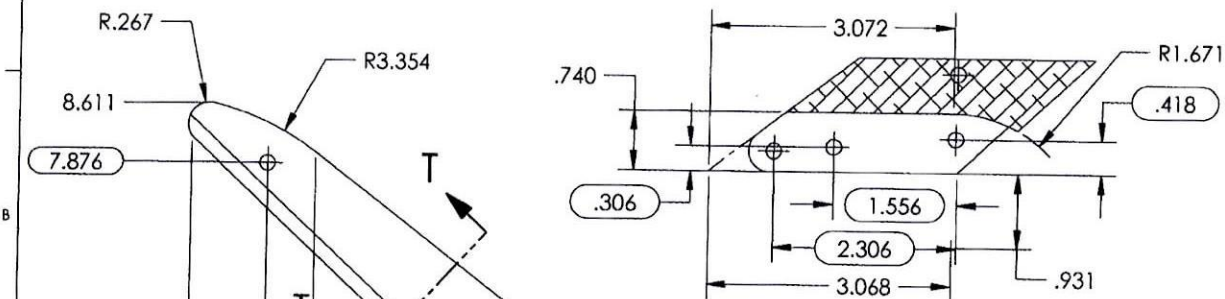
ORIGINAL DATE (MAY-1978)	06-10-80	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
DRAWN BY D SCHUR	TO BARBER			
DRAWING APPROVAL (06-10-80)				
CONTRACT NO.		DEFLECTORS		
(PLEASE OTHERWISE SPECIFY DIMENSIONS ARE IN INCHES UNLESS NOTED A/E: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SEE CAGE CODE B D7M26	DWG. NO. 647.3900	REV. C
		SCALE NONE		SHEET 5 OF 12

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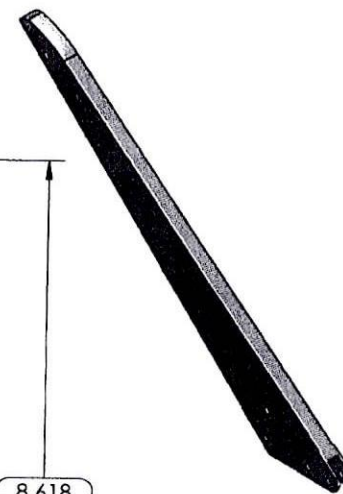
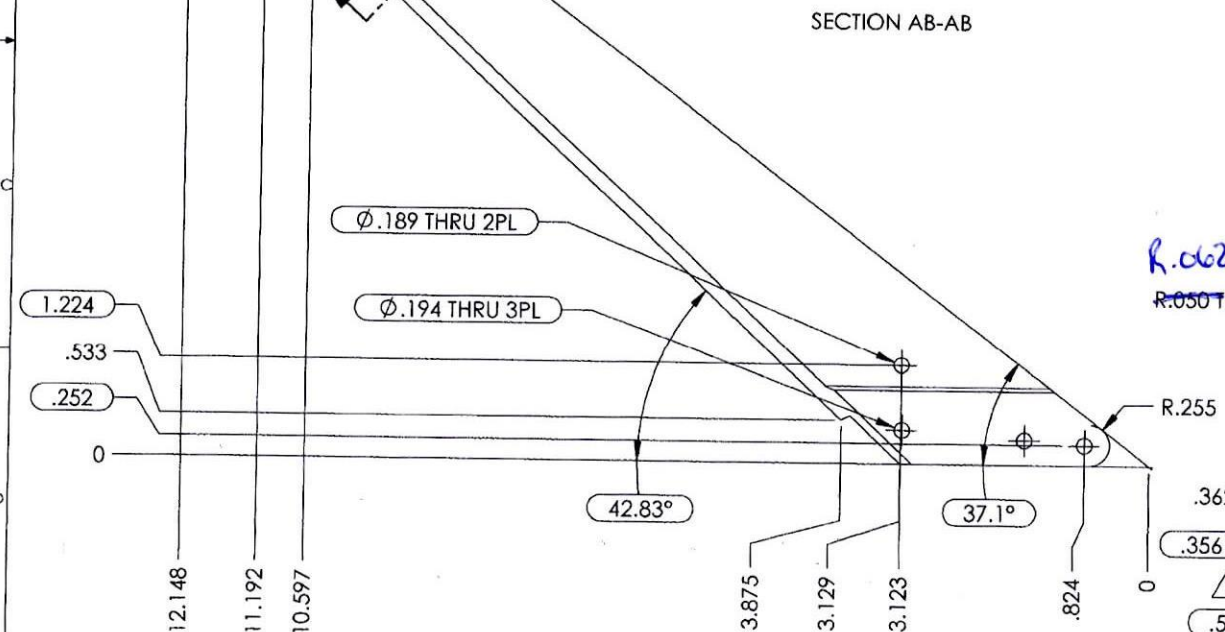
.175 X 45.0° TYP



SECTION T-T



SECTION AB-AB



647.3914

R.0625

~~R.050~~ TYP

— R.255

.356 MIN

.560

ORIGINAL DATE	
(MO-DA-YR)	07-10-09
DRAWN BY	CHECHER
D.SCHUR	D.BARKE
DRAWING APPROVAL	
P. BRAVO	
09-10-09	
CONTRACT No.	

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

DEFLECTORS

SHEET B	CAGE CODE D7M26	DWG. NO. 647.3900	REV C
SCALE NONE		SHEET 6 OF 12	

SHEET 6 OF 12

1 2 3 4 5 6 7 8

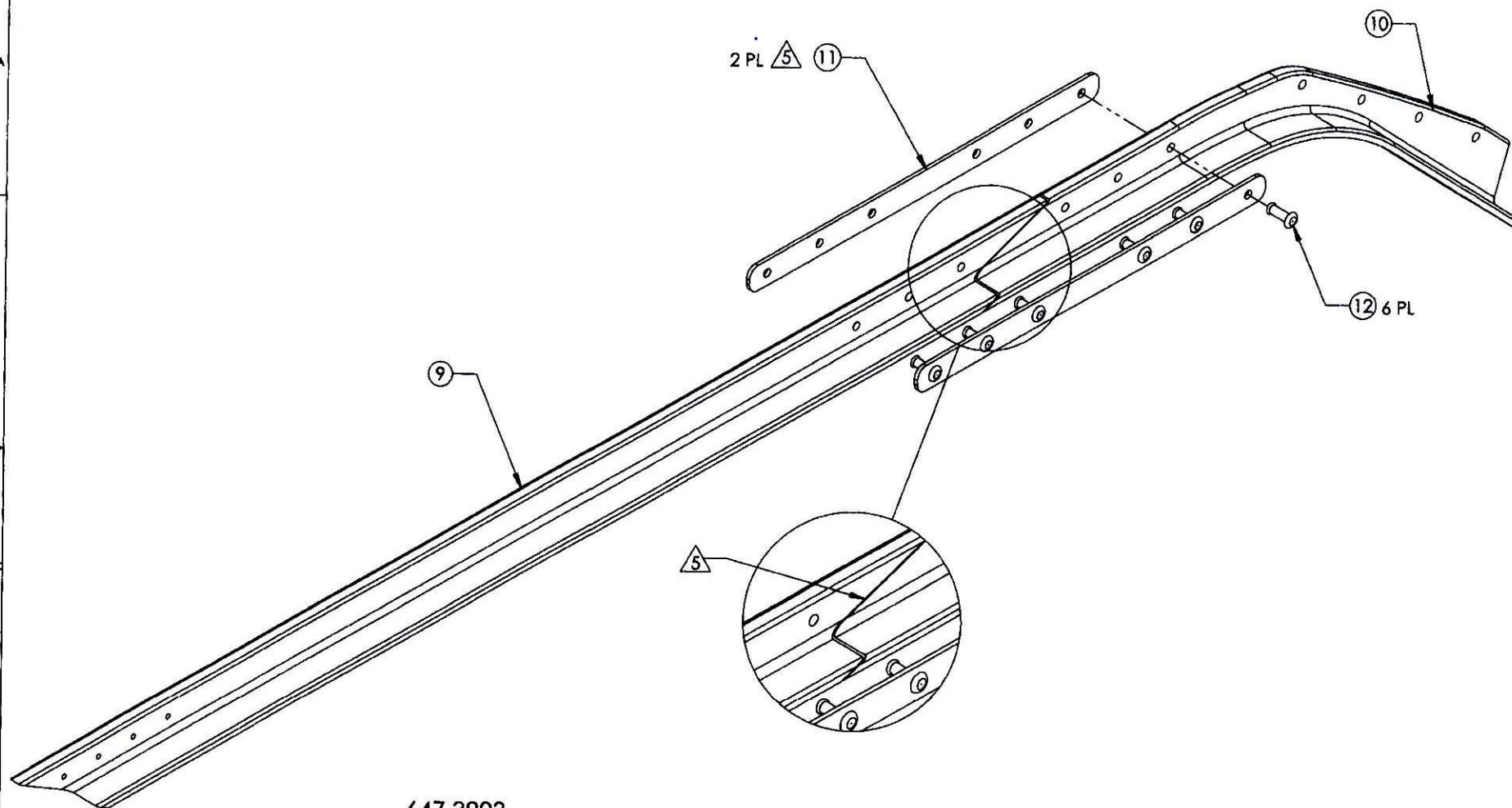
A

B

C

D

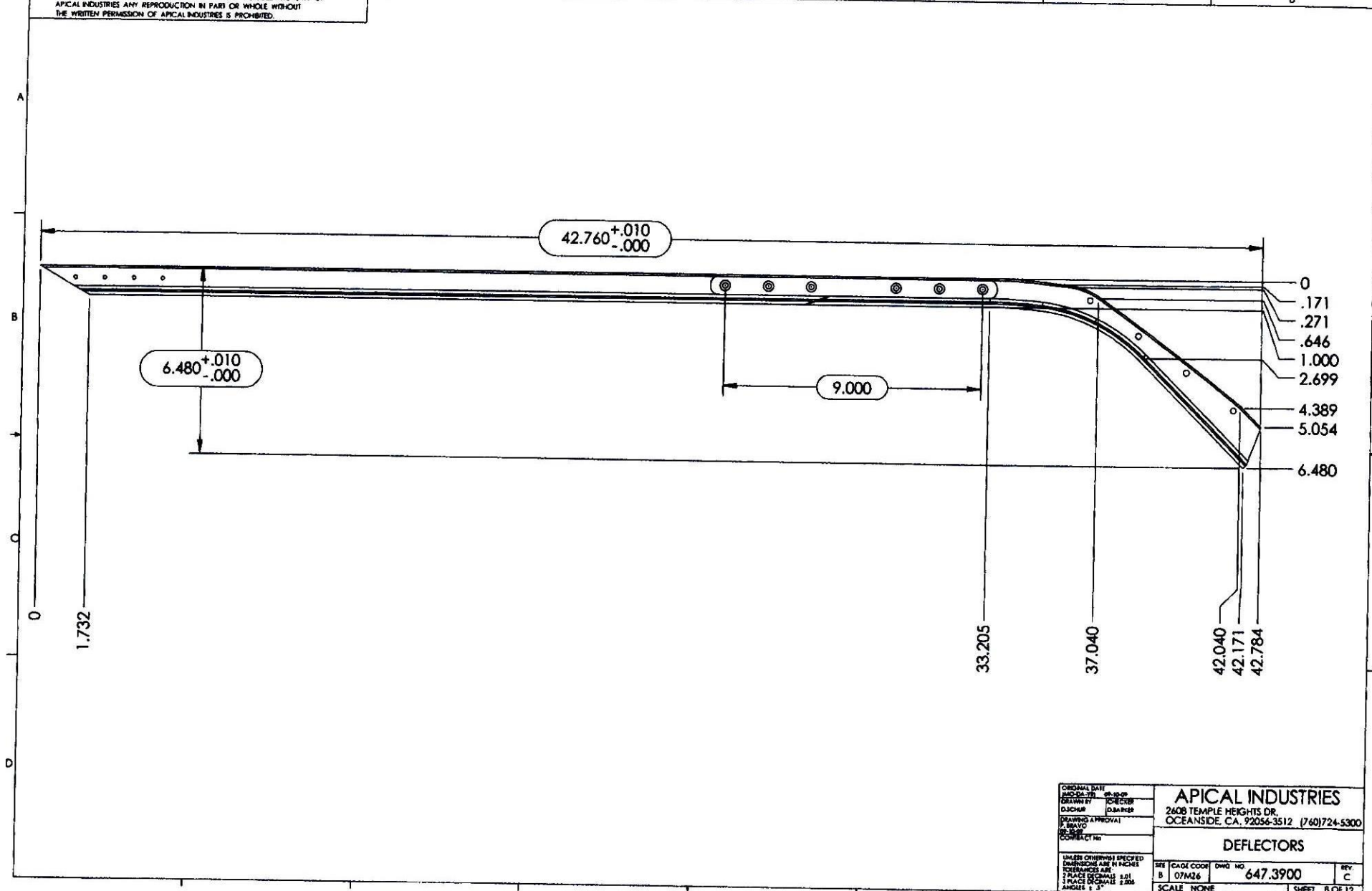
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647.3903

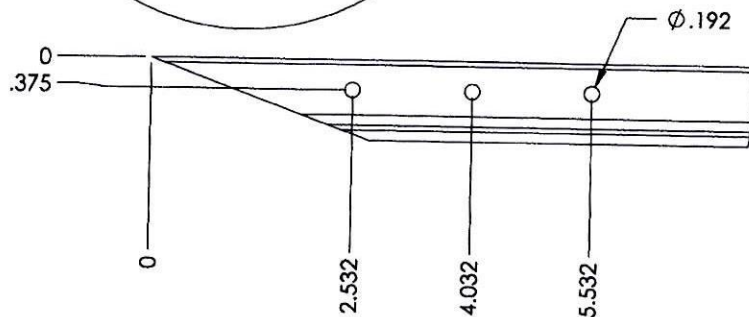
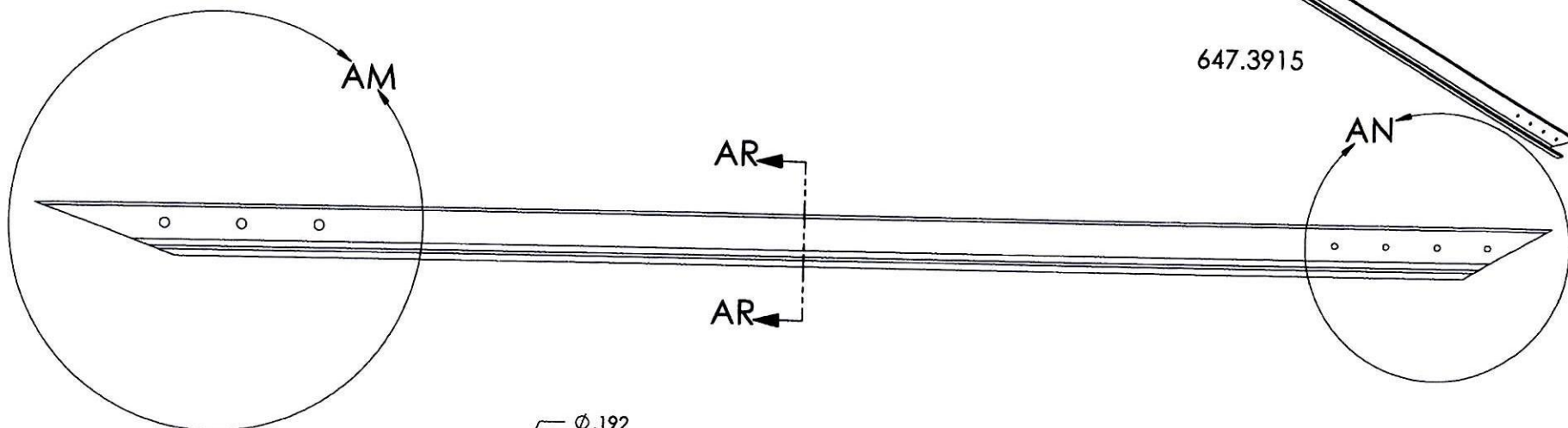
ORIGINAL DATE 12-01-1981 01:30 PM		APICAL INDUSTRIES	
DRAWN BY D.SCHUP		2606 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92054-3512 (760)724-5300	
DRAWING APPROVAL P. BLAYD		DEFLECTORS	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACES DECIMALS ±0.1 3 PLACES DECIMALS ±0.005 ANGLES ± 5°		SHEET B	REV. C
		CAGE CODE 07M26	DWG. NO. 647.3900
		SCALE NONE SHEET 7 OF 12	

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APICAL INDUSTRIES ANY REPRODUCTION IN PART OR WHOLE WITHOUT
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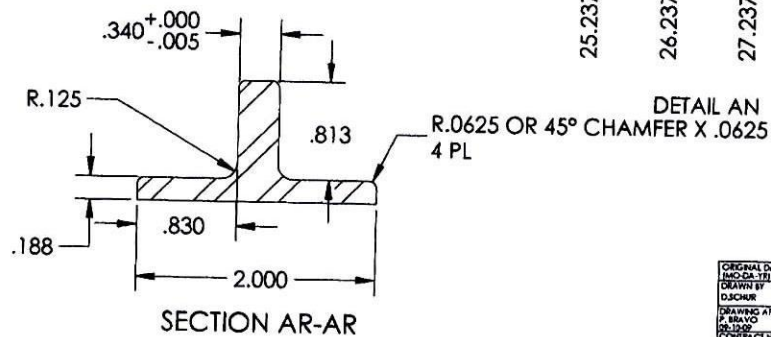


ORIGINAL DATE APICAL INDUSTRIES		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY D. SCHMIDT		DEFLECTORS	
CHECKED BY P. BRADY		647.3900	
CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS .251 2 PLACE DECIMALS .005 ANGLES 1° 5'		REV. C	
		SHEET 8 OF 12	

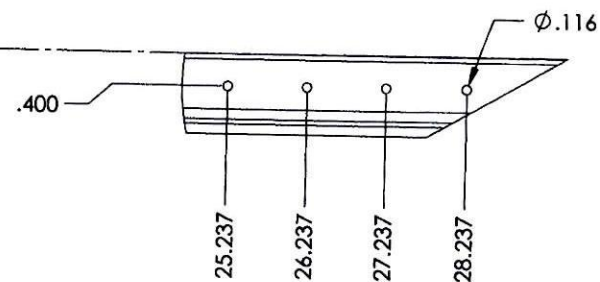
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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



DETAIL AM



SECTION AR-AR



DETAIL AN

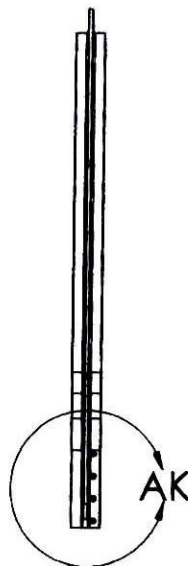
ORIGINAL DATE 1/20/00		OR 10/00	
DRAWN BY D. SCHUR		CHECKED BY D. SCHUR	
DRAWING APPROVAL P. BRAYO		CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ± 3°		SHEET 8	CAGE CODE 07M26
		DWG. NO. 647.3900	REV. C
		SCALE NONE	SHEET 9 OF 12

APICAL INDUSTRIES

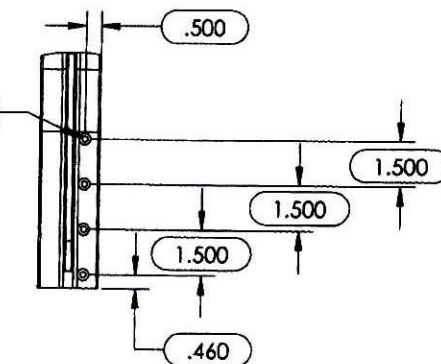
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

DEFLECTORS

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



4X $\phi .196 \pm .010$ THRU ALL
✓ $\phi .385 \pm .020 \times 100^\circ \pm 1.000^\circ$

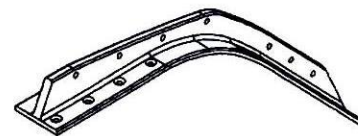


DETAIL AK

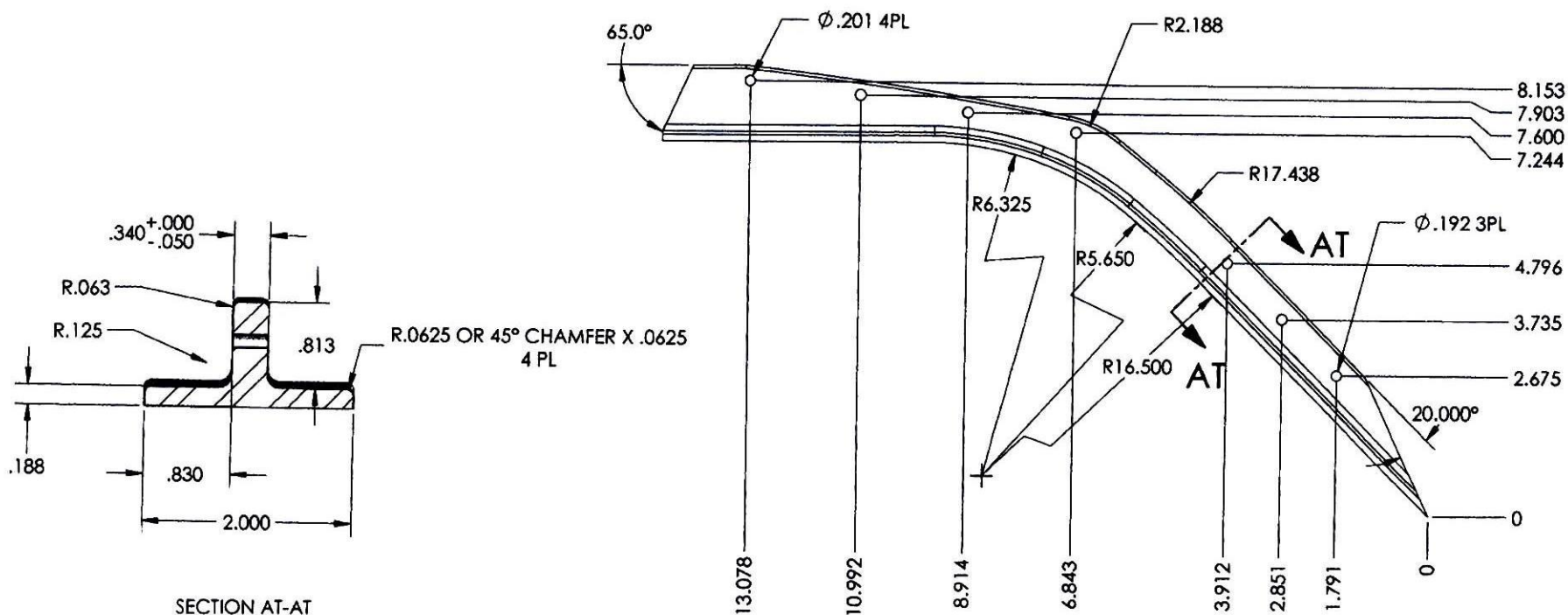
647.3915

ORIGINAL DATE (MM-DD-YY) 09-10-09		APICAL INDUSTRIES	
DRAWN BY D. CHURCH		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY J. BAKER		DEFLECTORS	
DRAWING APPROVAL P. BRAY		REV	
CONTRACT NO.		C	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		QTY 8	QTY 8
CAGE CODE 07M26		QTY 8	QTY 8
SCALE NONE		SHEET 10 OF 12	

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

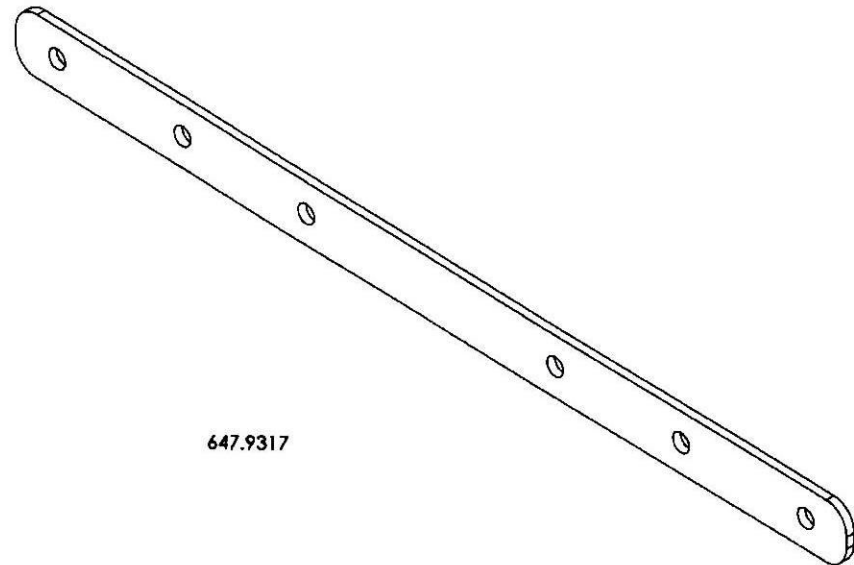


647.3916



ORIGINAL DATE REV. DATE		APICAL INDUSTRIES	
DRAWN BY: J. SCHUR		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: D. BARKER		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAYO		DEFLECTORS	
CONTRACT NO.		SCALE: NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET B	REV. C
CAGE CODE D7M26		DWG. NO. 647.3900	
		SHEET 11 OF 12	

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R.250
4 PL

.625

0

.500

2.000

3.500

6.500

8.000

9.500

10.000

.090

Ø.196
6 PL

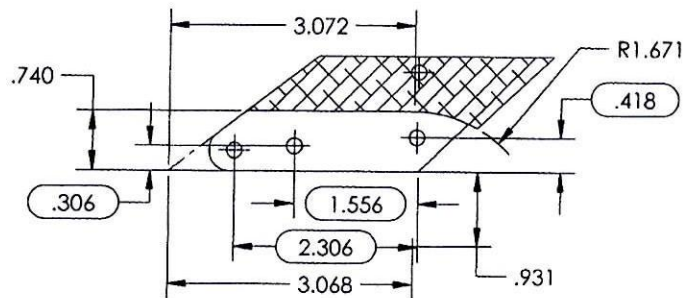
ORIGINAL DATE 08-10-09
 DESIGNED BY JCH/CHM
 DRAWN BY JCH/CHM
 CHECKED BY JCH/CHM
 APPROVED BY JCH/CHM
 UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE IN INCHES
 TOLERANCES ARE:
 FINISH DIMENSIONS ±.01
 HOLE DIMENSIONS ±.005
 ANGLES ±.1°

APICAL INDUSTRIES
 2408 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056-3512 (760)724-5300
DEFLECTORS
 SHEET 12 OF 12
 SCALE NONE
 REV. C
 DWG. NO. 647.3900
 CAGE CODE 07M26

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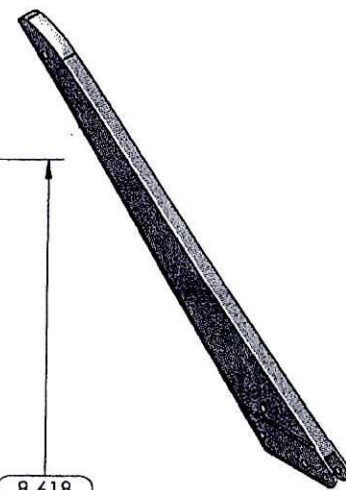
.175 X 45.0° TYP

SECTION T-T



SECTION AB-AB

REFERENCE ONLY



647.3914

8.618

this side varies from .096 to .093

R.050 TYP

R.255

.362^{+0.002}_{-0.000}

.356 MIN

.560

15.555"

6

0

8.24

3.123

3.129

3.875

42.83°

37.1°

Ø.189 THRU 2PL

Ø.194 THRU 3PL

8.611

7.876

R3.354

R.267

1.224

.533

.252

0

12.148

11.192

10.597

ORIGINAL DATE (MM-DD-YY) 09-10-06		APICAL INDUSTRIES	
DRAWN BY D.SCHUR		2608 TEMPLE HEIGHTS DR.	
CHECKED BY D.BARNER		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. WALVO		DEFLECTORS	
DATE 02-10-20		SHEET 6 OF 12	
CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		REV C	
SHEET		DWG. NO. 647.3900	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO33573**

Purchase Order Date 9/8/2016

PO Print Date 9/13/2016

Page Number 3 of 4

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA -- (Free Carrier)

Line Total:

7	150656	646.3719 DOUBLER REV. A	9/22/2016	7.00	\$6.25
---	--------	----------------------------	-----------	------	--------

Yes

9/22/2016

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total:

8	147490	647.3914 BREAKAWAY TIP REV. C	9/22/2016	12.00	\$11.55
---	--------	----------------------------------	-----------	-------	---------

Yes

9/22/2016

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total:

\$

9	150172	D2348 WEARPLATE REV. C	9/22/2016	13.00	\$9.62
---	--------	---------------------------	-----------	-------	--------

\$

Yes

9/22/2016

black Anodize per MIL-A-8625F Type I or IB or IC or II or IIB Class 2

Note:

9/13/2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912245

Date: 14-Sep-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
6 ea	Part: 647.3914 Breakaway Hard Anodize, Type III, Class 2 (MIL-A-8625) Job: 20090	Rev: C Line: 8	<i>Sp/6-5-14</i>
13 ea	Part: D2348 Wearplate Anodize, Type II, Class 2 (MIL-A-8625F) Job: 20091	Rev: C Line: 9	
DATE: <u>14/9/16</u> CERTIFIED SIGNATURE: _____ RECEIVER SIGNATURE: _____ Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. CERTIFICATE OF CONFORMANCE A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS. MADE IN CANADA.			